

5/27

SPLIT

DART AEROSPACE LTD	Work Order:	23677
Description: Angle Bracket	Part Number:	D3258-1
Dwg: D3258 Rev. A	Qty:	9 10
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.06.27	10
2	PG	Issue P/O: <u>7008289</u> Email or Ship DXF file to vendor Laser Cut D3258-1 as per Dwg D3258 Material release note is required	U	05.06.28	10
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	DL	05/07/28	10
4	QC6	Inspect dimensions as per Dwg D3258	2	05-08-17	10
5	GA	Deburr if necessary	SAD	05/08/17	10
6	ST	Identify and Stock 1.60	CL	05/08/17	10
7	AC	Cost / part <u>23.11</u>	SAC	05-10-20	9
8	DC	Close W/O <u>23.11</u> Inspect Level 21	DP	05/10/26	9

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	

5b	GA	Form per dwg D3258	SB	05/08/23	9	PTD
5c	QC5	Inspect				

RELEASED

05-08-24 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/08/17	5b SC	Permanent change as shown on drawing	U	05/08/17 05-10-26		U	2 05-08-24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/08/23	5B	1 piece was over bend	U	Scrap + destroy	SRS 05/08/23	U 05/08/23	U 05/08/23	U 05/08/23

Part No: D3258-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: U Date: 05/10/20

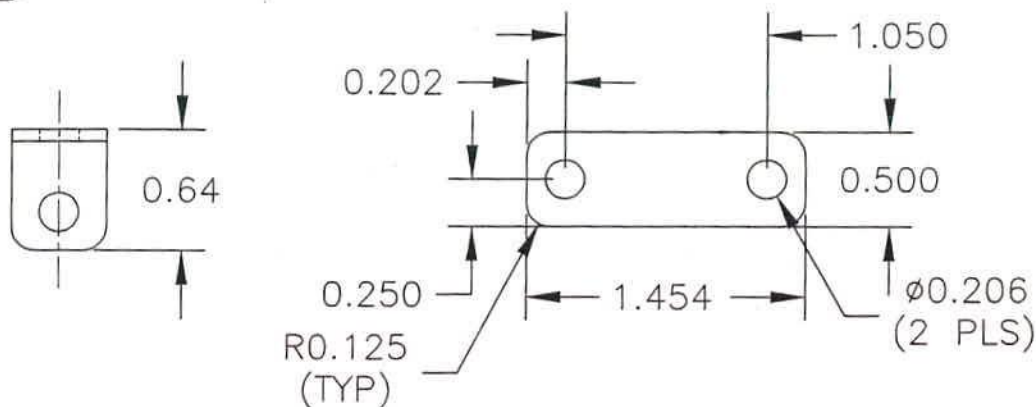
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

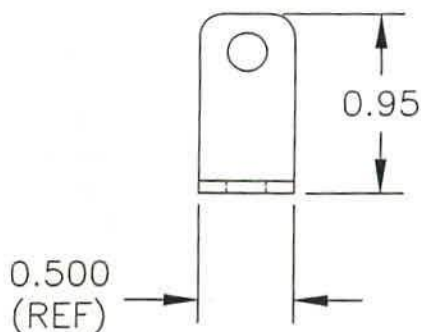


DESIGN R	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3258	REV. A SHEET 1 OF 1
DATE 04.01.27	TITLE ANGLE BRACKET		SCALE 1:1
A	04.01.27	NEW ISSUE	

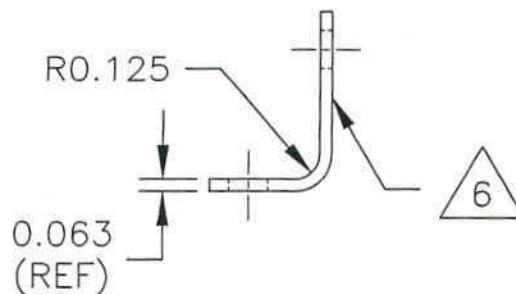
RELEASED
04.04.05



D3258-1 FLAT PATTERN



D3258-1 ANGLE BRACKET



NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- 2) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23677

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 27, 2005
08:10 am

Work Order No : 0023677
Project Name : D3258-1
Project For : WK527
Work Order Type : Main
Main WO Number :
House Part Number : D3258-1
Description : Angle Bracket
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 06-27-05
Est Finish Date : 07-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

9023942

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

 燁茂實業股份有限公司
YIEH MAU CORP.

INVOICE NO. : F03MB57
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304, NO.4 (SIC)
FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE. AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.
SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972885 FAX:(07)6973006
CERTIFICATE NO:9212243
DATE OF ISSUE:12/31/2003

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120" (7425-8401)	1	1,442	3,179	YU129992	2AS68986C-1	281	687	56	81	157	4.6	50	110	26	4	804	1819	3.1
20GA/48"X120" (7426-2619)	1	1,446	3,188	YU226021	29S65042BA-21	293	636	58	81	157	4.4	55	115	31	4	808	1808	3.6
18GA/48"X120" (7426-5059)	1	1,428	3,148	YU226201	2AS68982B-21	303	672	56	83	165	4.2	52	115	23	2	814	1824	3.8
16GA/48"X96"	1	1,414	3,117	YU225206	2AS68037-21	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96"	1	1,412	3,113	YU225206	2AS68037-22	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5166)	1	1,413	3,115	YU225206	2AS68037-23	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-1	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-2	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,215	2,679	YU225390	2AS67026B-3	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/60"X96" (7426-5497)	1	1,438	3,170	YU226508	2BS69861A-23	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X120" (7426-5612)	1	1,411	3,111	YU226508	2BS69861A-22	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X144" (7426-7949)	1	1,434	3,161	YU226508	2BS69861A-21	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
14GA/48"X96"	1	1,432	3,157	YU130016	2AS68134B-2	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-3	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X120"	1	1,435	3,164	YU225138	2AS68038B-1	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120"	1	1,437	3,168	YU225138	2AS68038B-2	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120" (7426-8160)	1	1,437	3,168	YU225138	2AS68038B-3	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X144" (7426-8244)	1	1,425	3,142	YU130011			640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/60"X96"	1	1,413	3,115	YU130125			656	54	83	162	5	47	111	27	2	810	1808	3.6
19		26,834	59,158															

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.

ICE WITH ASTM A240, A480,
766D.

YIEH MAU CORP.

Manager of Quality Assurance Section

16ga 304 2B

order order
16ga 304 2B
not cut 1 used
3.15 mch. in house



New Zealand Steel Limited
Greenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(06) 235 5500 / 235 5655 Waiuku
Fax: (09) 375 9959

TEST CERTIFICATE

R/L 4717/2006

CUSTOMER	Wilkinson	P41006ME003	SPECIFICATION	ASTMA1011 CS Type B	CERTIFICATE No	TC101993
CUSTOMER Q/N	90-31N-294		PRODUCT	HOT ROLLED PICKLED & OILED	PAGE	1 of 1
MILL Q/N	453750		DIMENSIONS	0.104" x 48" Coil 12 GA M.S.	DATE	29 December 2004

		CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							
PACK NUMBER	HEAT No	C	S	Mn	P	S	Cr	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS	r ()	LENGTH [mm]
		x100															x1000							
HP-942195-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1						Good					955
HP-942196-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1						Good					955
HP-942197-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					955
HP-942198-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					955
HP-942200-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1						Good					955
HP-942201-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					955
HP-942202-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					955
HP-942203-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					955
HP-942204-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					889
HP-942205-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					955
HP-942206-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1						Good					951

YIELD	GAUGE LENGTH (G.L.)		PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=20mm	(C)=80mm	(E)=2"	(A)=0	(C)=145	(C)=5mm x 5mm	(A)=C+Mn/6	(C)=C+1/80+Si/24 (D)=
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 x Bo	(F)=8"	(B)=r90	(D)=(0.4r90-2r45)/4	(D)=2.5mm x 10mm	(B)=C+Mn/6+(Cr+V+Ni)/5+(Cu+Ni)/15	
						(E)=5mm x 10mm		

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC/STALLURGIST

11GA K/O

PT KRAKATAU STEEL (PERSERO)

MILL CERTIFICATE

PURCHASER : MARUBENI-ITOCHU STEEL CANADA INC.,
METRO TOWER 11, SUITE 710, 4720 KINGWAY, BURNABY, B.C.,
V5H 4N2, CANADA
COMMODITY : HOT ROLLED COIL

LC. NO. : 104-LCI-906188
CERTIFICATE NO. : B F630207037630/MC/DM/1X/04
DATE : SEPTEMBER01,2004
LOT. NO. : 1
DELIVERY ORD.NO. : 0207
SUPPLIER ORD.NO. :
ORDER NUMBER : F630207


SPECIFICATION : ASTM A 1011 CB TYPE B P40518ME005.

PAGE : 001 OF 001

HEAT NO.	SLAB NO	COIL NO. AND PACKING NO	TEST- NO.	DIMENSION T X W X L (INCH)	QTY (N)	CHEMICAL COMPOSITION X100(%)										TENSILE TEST			IMPACT TEST	
						C	SI	MN	P	S	AL	YS	TS	EL	TEST	IN/MM2	IN/MM2	(%)	TEST	AVG
52731P	1900	129317B	20202510.104	NOMX48"XC	1	113.9	1.4	28.5	1.0	1.0	4.11	312	391	40	1800D					
64878P	5500	129325B	20202310.104	NOMX48"XC	1	113.1	1.0	31.4	1.7	1.3	3.91	327	409	40	1800D					
"	1400	129453B	2020281	"	1	"	"	"	"	"	"	314	415	38	"					
64880P	1100	129350A	20202110.104	NOMX48"XC	1	113.6	1.3	26.7	0.9	1.3	4.21	319	406	38	1800D					
52728P	3109	129352A	20201810.119	NOMX48"XC	1	115.0	2.0	32.8	1.4	0.6	4.51	336	433	40	1800D					
"	"	129352B	"	"	1	"	"	"	"	"	"	"	"	"	"					
52744P	3109	129353B	20201910.119	NOMX48"XC	1	113.9	0.8	30.2	1.2	1.5	4.41	329	413	36	1800D					
52728P	1200	129241A	20201810.119	NOMX48"XC	1	115.0	2.0	32.8	1.4	0.6	4.51	336	433	40	1800D					
"	"	129341B	"	"	1	"	"	"	"	"	"	"	"	"	"					
64883P	1300	129372A	20200910.134	NOMX48"XC	1	114.8	1.0	27.1	0.9	0.9	3.81	324	413	40	1800D					
"	"	129372B	"	"	1	"	"	"	"	"	"	"	"	"	"					
64878P	1300	129396B	20201610.134	NOMX48"XC	1	113.1	1.0	31.4	1.7	1.3	3.91	317	411	36	1800D					
52728P	1400	129431A	20201810.134	NOMX48"XC	1	115.0	2.0	32.8	1.4	0.6	4.51	336	433	40	1800D					
52684P	1400	129208A	20031010.188	NOMX48"XC	1	113.9	1.4	32.7	0.5	1.3	3.41	306	403	42	1800D					
"	"	129208B	"	"	1	"	"	"	"	"	"	"	"	"	"					
52727P	1100	129115B	20131910.188	NOMX48"XC	1	115.0	1.7	25.1	1.4	1.0	4.31	323	428	42	1800D					
64882P	1400	129377A	20162410.188	NOMX48"XC	1	113.0	1.3	28.4	0.8	1.0	4.21	301	376	38	1800D					

RS/H904/023, ISSUE NO : 03
WE HERERY CERTIFY THAT THE MATERIAL DESCRIBED ABOVE HAS BEEN TESTED
AND COMPLIES WITH THE TERMS OF THE ORDER CONTRACT

DIVISION OF QUALITY CONTROL


ACHMAD SAFIT
SUPERINTENDENT

PHONE : (0254) 371015

Wed Jun 29 10:19:16 2005

From WILKINSON VAN